

Work Order ID 58940

Thursday, May 20, 2010 10:29:59 AM



Page 1

Item ID: D350-607-043

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket

Stop



Start Date: 5/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-5-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-607-1

A

100

0.00



DOCUMENT CONTROL B

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043 CHG005

10/25/31 10/05/28

6 10/06/01

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/05/31 10/05/31

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: M113519
Exp Date: 7/3 9/12/23

10/05/31 10/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 6/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 1260731			ⓧ			
140 Packaging Packaging	Pick Kit Memo K607043 B 59146 14	0.00 0.00							
150 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	S 1260731			ⓧ			

W/O:		WORK ORDER CHANGES					
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Start Date: 5/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-043								
	Location: <u>NAVG</u>								
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/06/01 10/06/01

C210/611

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 6/4/2010

Required Qty: 1.00

Component Item ID/ D2728-3	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 110	Unit of Each	Qty on 0.0000	Qty per Kit 2	Qty	Date	Status
Dart Logo label											SB 10/05/31	
D356-607-241		Manufactured	No			140	Each	0.0000	1		B59146 SB 10-6-1	
Basket Clamp Assembly											SB 10/05/31	
D2022-101		Manufactured	No			110	Each	237.0000	5		SB 10/05/31	
Spacer												
Location Loc Qty Loc Code												
					ST504		237				5	SB 10/05/31
					45885		37					
					50746		100					
					52325		100					
D2221		Manufactured	No			110	Each	0.0000	1			
350 Basket Base												
D2258-200		Manufactured	No			110	Each	6.0000	1		SB 10/05/31	
Placard 200lb												
Location Loc Qty Loc Code												
					ST505		6				I	
					56229		6					
D2332:041		Manufactured	No			110	Each	14.0000	1			
Lid Prop Assembly 6.69" long												
Location Loc Qty Loc Code												
					ST512		14				I	SB 10/05/31
					57344		4					
					57645		10					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 58940



Parent Item: D350-607-043



Parent Item Name: Heli-Utility-Basket

Start Date: 5/20/2010

Required Date: 6/4/2010

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2530		Manufactured	No			110	Each	9.0000	1			
Handle Weldment												

Location	Loc Qty	Loc Code
ST506	9	
57736	1	
57964	2	
58428	6	

SB - 10/05/31

D2535		Manufactured	No			110	Each	142.0000	2			
Spring												

Location	Loc Qty	Loc Code
ST504	142	
56355	42	
58331	100	

2 SB 10/05/31

D2537		Manufactured	No			110	Each	57.0000	2			
Bushing												

Location	Loc Qty	Loc Code
ST504	57	
57722	17	
58429	40	

2 SB 10/05/31

D2931		Manufactured	No			110	Each	862.0000	2			
Bumper												

Location	Loc Qty	Loc Code
ST504	862	
46064	862	

2 SB 10/05/31

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58940

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket






Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
 IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
 per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/20/2010

Required Date: 6/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2989-041		Manufactured	No			110	Each	0.0000	1			
						B58947		(1X)			5/10/05/31	
Basket Lid Assembly												
D2989-043		Manufactured	No			110	Each	0.0000	1			
						B5895		(1X)			5/10/05/31	
Basket Lid Assembly												
AN3-16A		Purchased	No			110	Each	65.0000	2			
											5/10/05/31	
Bolt												
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
						ST352	65					
						113845	45					
						114523	20					
AN4-13A		Purchased	No			110	Each	119.0000	2			
											2 83 10/05/31	
Bolt												
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
						ST351	119					
						114523	119					
AN4-22A		Purchased	No			110	Each	228.0000	7			
											2 83 10/05/31	
Bolt												
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
						ST359	228					
						111965	128					
						114523	100					

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58940

Parent Item: D350-607-043

Parent Item Name: Heli-Utility-Basket


Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Date: 5/20/2010

Required Date: 6/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
AN5-17A		Purchased	No			110	Each	151.0000	4			
												
Bolt												

Location	Loc Qty	Loc Code
ST323	46	
114324	46	
ST339	105	
113538	5	
114330	100	

4 SS 10/05/31

MS20600-AD4W3

Purchased

No

110

Each

1,789.000

2

Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1789	
106375	3	
107939	822	
111636	964	

2 SS 10/05/31

AN960JD416

Purchased

No

110

Each

0.0000

14

Washer

AN960JD416L

Purchased

No

110

Each

413.0000

2

Washer

Location	Loc Qty	Loc Code
ST346	413	
110153	413	

2 SS 10/05/31

AN960JD516

Purchased

No

110

Each

0.0000

4

Washer

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 58940



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Required Date: 6/4/2010

Comments: IPP Rev:E as Per DSI9318 06-01-24 JLM
IPP Rev:F ECN1068 07-12-21 DD verified by:ec IPP rev:G as
per ecn10-545 DD 10.04.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-------------	-----	------	--------

MS21042L4



Nut

Purchased

No

110

Each

2,705.000

9



Location

Loc Qty

Loc Code

ST139

2

111827

2

ST300

2703

113422

80

114523

1615

114718

1000

9063

8

MS21042L5



Nut

Purchased

No

110

Each

532.0000

4



Location

Loc Qty

Loc Code

ST300

532

113523

26

113537

3

114108

3

114437

100

114449

400

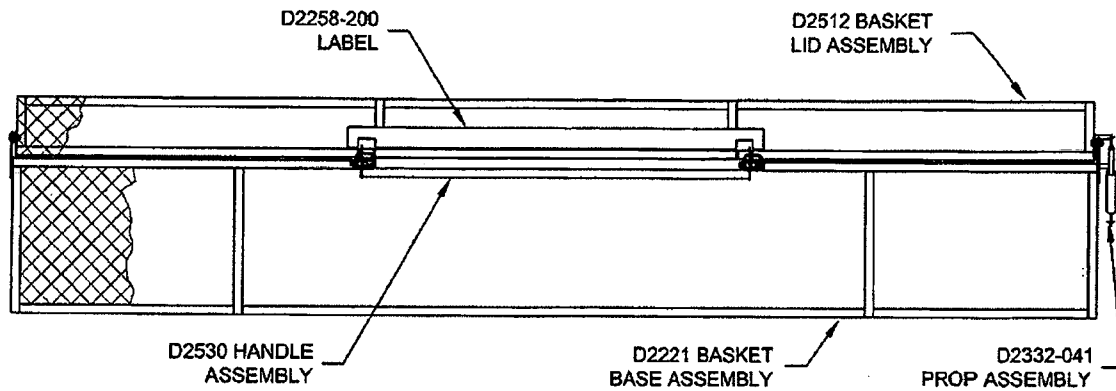
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

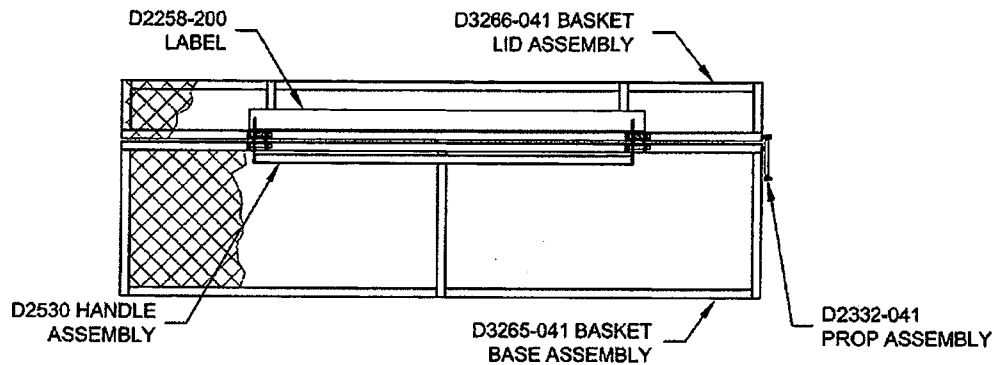
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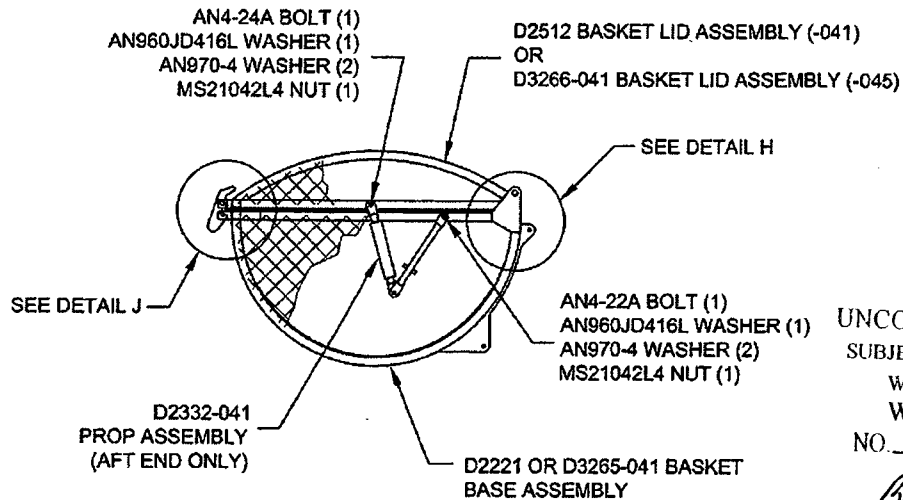
NOTE: Date & initial all entries



D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™



VIEW C-C
PROP ARM DETAIL

Figure 5 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38940

BS 10-5-20

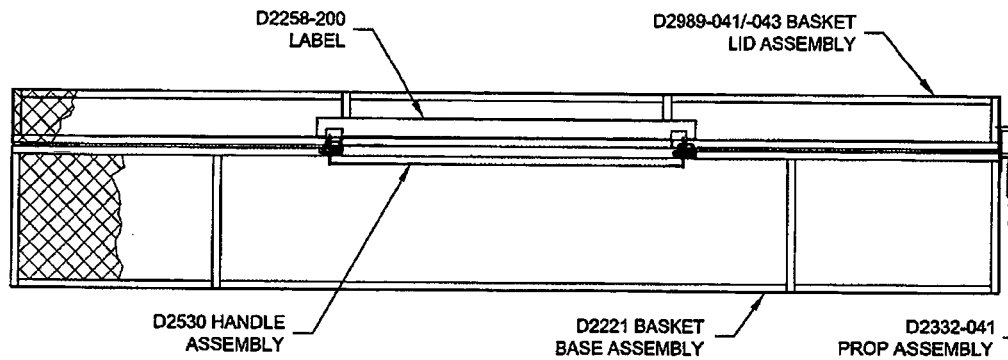
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

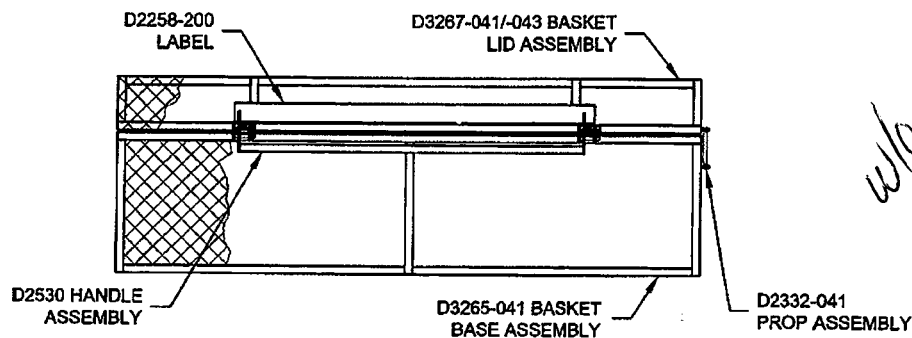
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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

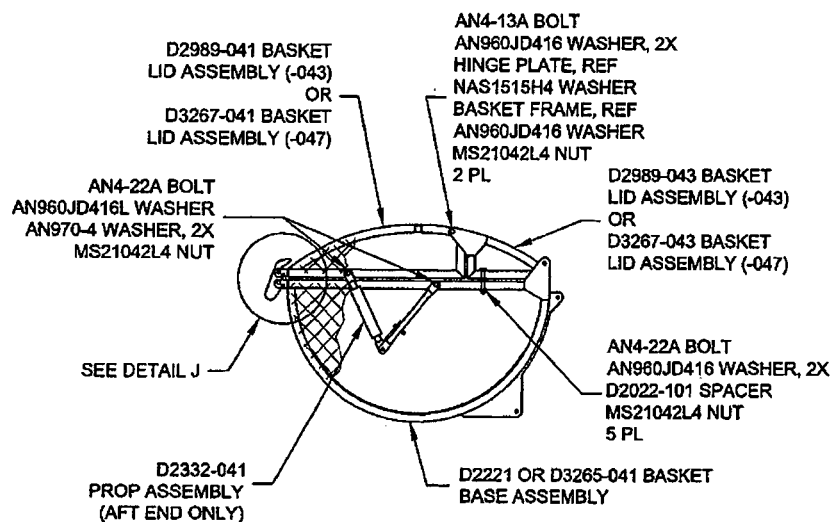
NOTE: Date & initial all entries



D350-607-043 HELI-UTILITY- BASKET™



D350-607-047 HELI-UTILITY- BASKET™



**VIEW C-C
PROP ARM DETAIL**

Figure 6– Basket Replacement Parts

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Date: 10.03.10

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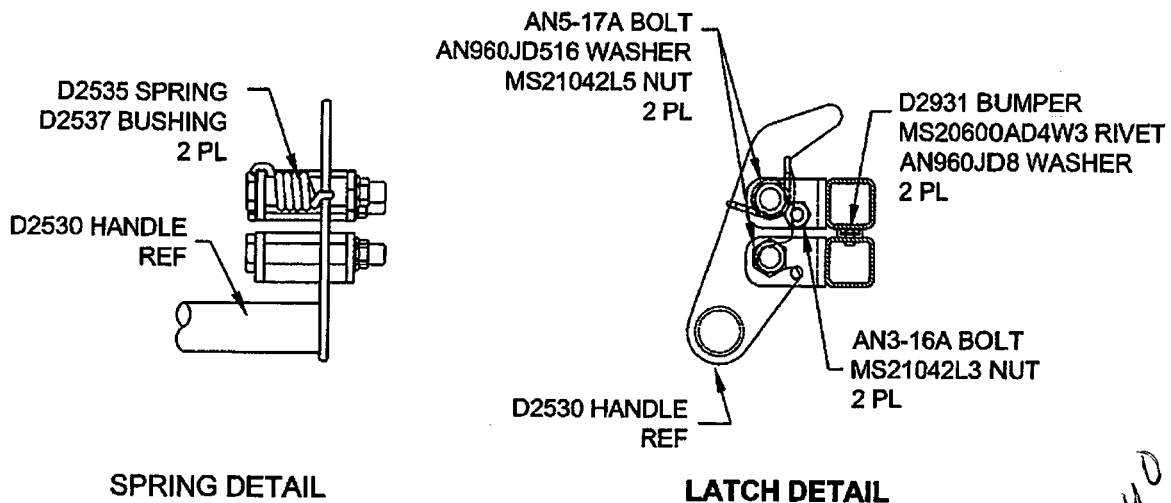
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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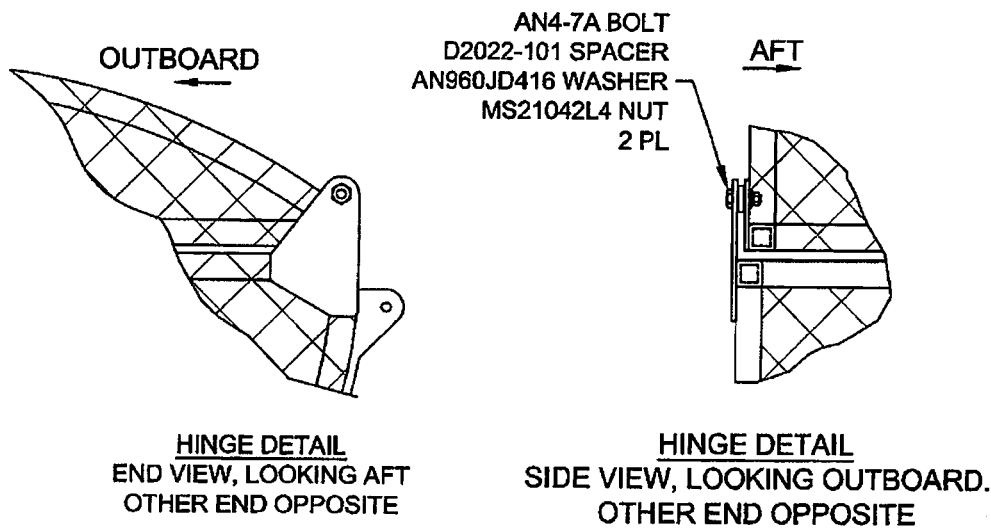
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DETAIL J:
HANDLE WELDMENT**

WB 58940



**DETAIL H:
HINGE**

Figure 7 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries